

Work Order ID 126379

November-06-14 7:43:07 AM

126379

Page 1

Item ID: D4776-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Skidtube Clevis

Start Date: 11/06/14 Start Qty: 30.00

30

Cust Item ID:

Required Date: 11/14/14 Req'd Qty: 30.00

30

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4776

D

100

0.00

100

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut Blank at 4.400"

30

Ø

DAS
20
9-89

14-11-07

110

0.00

110

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine per folio FB168

DWG REV: D

FOLIO REV: C

DAS
20
9-89 14-11-11

30

Ø

DAS
44
9-89 14/11/09

2- deburr and break all sharp edges

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Item ID: D4776-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Skidtube Clevis
 Start Date: 11/06/14 Start Qty: 30.00 ***30*** Cust Item ID:
 Required Date: 11/14/14 Req'd Qty: 30.00 ***30*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
120									
QC	Memo	0.00							
Quality Control									
130	QC8- Inspect parts - second check	0.00							
130									
QC	Memo	0.00							
Quality Control									
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	Memo	0.00							
Hand Finishing									

DAS 34 9-89

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Item ID: D4776-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Skidtube Clevis
 Start Date: 11/06/14 Start Qty: 30.00 ***30*** Cust Item ID:
 Required Date: 11/14/14 Req'd Qty: 30.00 ***30*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC7-Inspect Chemical Conversion Coat	0.00							
150						(30)			9B
QC	Memo	0.00							14-11-13
Quality Control									
160	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
160	<i>m 129808.</i>					30	φ	14-11-13.	DAS 34 9-89
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 11:40. OVEN TEMPERATURE: 320° FINISH TIME: 12:10.								
170	QC3- Inspect Part Finish	0.00							
170						(30)			DAS 38 9-89
QC	Memo	0.00							
Quality Control									

NOV 13 2014

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Item ID: D4776-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Skidtube Clevis
 Start Date: 11/06/14 Start Qty: 30.00 ***30*** Cust Item ID:
 Required Date: 11/14/14 Req'd Qty: 30.00 ***30*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Identify as per dwg & Stock Location: S127	0.00				30			
180									
Packaging	Memo	0.00							
Packaging									
							DAS		
							06		
							9-09		
								NOV 13 2014	
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

14/11/17
ME
14-11-14

Picklist Print

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Work Order ID: 126379

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Parent Item: D4776-3

D4776-3

Parent Item Name: Skidtube Clevis

Start Date: 11/06/14

Required Date: 11/14/14

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP REV A: NEW ISSUE JFS 13/03/07 VERIFY BY: JLM IPP
REV:B 13.09.26 AS PER REV.B DD VERF:JLM IPP REV:C AS
PER REV. PC1 JFS 13/11/07 VERIFY BY: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.500X02.50		Purchased	No			100	f	54.7150	0.367	12			

M6061T6B1 500X02 500

6061-T6 Bar 1.50 x 2.50

**

11.500'

DAS
20
9-89

14-M-07

Location	Loc Qty	Loc Code
MAT004	54.715	
124572	1.35	
124681	3	
16742	9.38	
m128980	11.935	
m129530	5.05	
m129666	12	
m129845	12	

NOT Pulled -> 129972

11.500'

126379

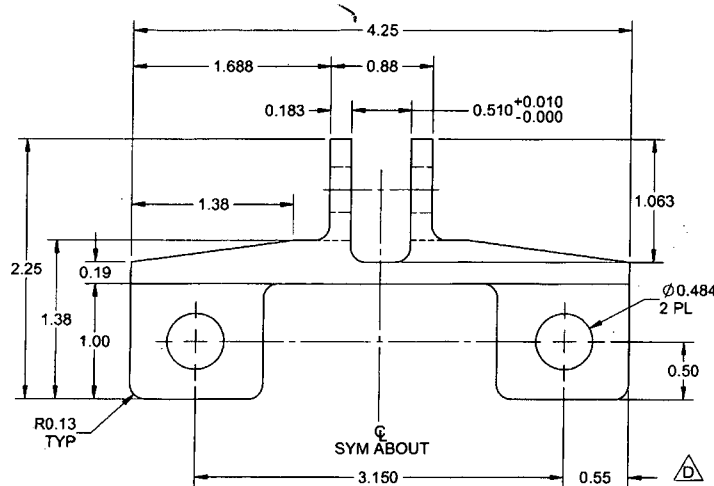
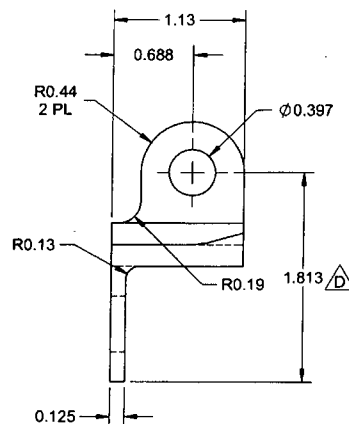
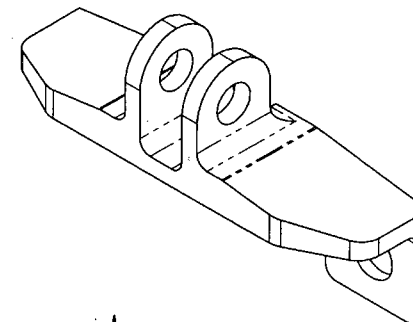
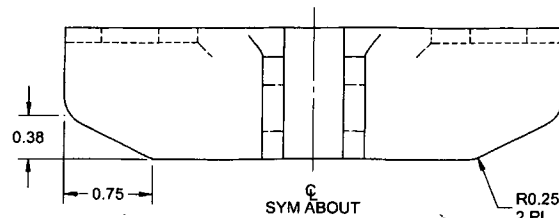
FIRST ARTICLE INSPECTION CHECKLIST

[illegible]

DAS		DAS		DAS		DAS	
Measured by:		44		Audited by:		JFC	
Date:		14/11/09		Date:		2014-11-12	
Preliminary Approval:				Preliminary Approval:			
Date:				Date:			

Rev	Date	Change	Revised by:	Approved
A	14.08.27	New Issue	KJ	

8 7 6 5 4 3 2 1



GRAIN
DIRECTION

alo
76379

RELEASED
2014-07-30

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8
(OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER DART QSI 044 6.1
- 7) WEIGHT: 0.18 lbs

D4776-3 SKIDTUBE CLEVIS

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D4776	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BASKET STRUT MACHINED PARTS	NTS
DATE	14.07.14	<small>COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1